

Date: Thursday, 2/21/2008 9:26:08 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	37567			Part Number	D2574	
Estimate Number	10534			Drawing Number	D2574 REV E	
P.O. Number	:			Project Number	N/A	
This Issue	2/21/2008	S.O. No. :		Drawing Revision	E	
Prsht Rev.	NC			Material	:	
First Issue	1/1	Type	MACHINED PARTS	Due Date	3/15/2008	Qty: 6 Um: Each
Previous Run	37553					
Written By	<u>1/21/08 02/21</u>					
Checked & Approved By						
Comment	Est Rev: 1 As Per RevE 06-01-27 JLM					

Additional Product

Job Number:	
Seq. #:	Machine Or Operation:
1.0	D6101005
	
Comment:	Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <u>B31388</u>
2.0	HAAS1
	
Comment:	HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>37567</u> Double check by: <u>DJP</u>
	1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges:
3.0	MILLING CONV.
	
Comment:	CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574
4.0	QC2
	
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/03/82
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 37567

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

SP/08-03-05

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

11

08-03-04

X6

7.0 POWDER COATING

POWDER COATING



M107005

6X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ML

08/03/06

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



11

08-03-06

6X

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 9433

AS

08/03/06

X6

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/06

6

Job Completion



2008/3/07

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37567
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.443	.440	.440	.440		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.003	8.005		
F	0.490	0.510		.499	.503	.515	.517		
G	0.257	0.262		.260	.259	.259	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.501	.500	.500	.502		
J	1.174	1.184		1.179	1.178	1.178	1.179		
K	0.558	0.578		.570	.569	.569	.570		
L	1.174	1.184		1.179	1.178	1.178	1.179		
M	1.365	1.375		1.370	1.369	1.369	1.369		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	4.119	4.129		4.126	4.122	4.121	4.122		
P	0.115	0.135		.125	.125	.124	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.251		
S	0.115	0.135		.123	.126	.124	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.236	.239	.238	.237		
W	0.115	0.135		.130	.133	.132	.130		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.367	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.615	.627	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.248	.248	.247		
AE	1.500	1.520		1.515	1.512	1.511	1.514		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.266	.261	.264	.270		
AH	0.240	0.260		.247	.249	.248	.249		
AI	2.000	2.020		2.005	2.002	2.002	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>Amber / SA</i>	Audited by:	
Date:	<i>08/03/04</i>	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

~~1.6 weeks~~

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D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.004	8.004				
F.	0.490	0.510		-.501	-.502				
G	0.257	0.262		.258	.258				
H	0.375	0.380		.376	.376				
I	0.490	0.510		.503	.503				
J	1.174	1.184		1.175	1.175				
K	0.558	0.578		.572	.572				
L	1.174	1.184		1.175	1.175				
M	1.365	1.375		1.370	1.370				
N	2.495	2.505		2.495	2.495				
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AG	0.240	0.280		-.253	-.253				
AH	0.240	0.260		.251	-.251				
AI	2.000	2.020		2.004	2.003				
AJ	0.023	0.043		-.037	-.033				
Accept/Reject									

Measured by: *SA*
Date: 08/03/05

Audited by: *John*
Date: 08.03.05

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